



Non-Conformance Report

Reviewed
DQA:
Date:

Printed on: Tuesday, January 27, 2015

Details			
Raised Date 8/22/2014	Status Closed	Owner Smith, Patrick	Number NCR14-4145
Target Date 10/31/2014	Standard	Severity MAJOR	
Process Inspection		Audit	
Raised By Person Downing, Eric M	Raised Against (Department or Supplier) Manufacturing\Receiving\Stores\Packaging		Fault Category Other\Process
Details			
corrosion was found during the alodine process. the corrosion was found on the flat non bent side of the part D3302-1 B115854 qty x 10 and also D3302-3 B120236 qty x 10 parts are effected. both work orders were cut at T.P.I Industries Inc on PO#24574.			
Keywords		Product D3302-1 &-3	
Document		Root Cause Process Improvement	
Closed By Smith, Patrick	Closed Date 10/5/2014	Resolution Document Update	

Corrective Action			
Target Date 10/6/2014	Owner Downing, Eric M	Closed Date 10/5/2014	Closed By Smith, Patrick
Details			
Receiving work order updated the ensure the parts are processed or protected from environment.			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	
1	Downing, Eric M	8/29/2014	9/5/2014
scrap all parts		parts scraped on work orders	
2	Gregoire, Michael	8/29/2014	10/2/2014
contact supplier to find out how Dart's material is being stored and request		Material was issued to vendor from our inventory June 16th. Finish product was returned to us July 11th. Storage is not an issue. NCR was raised Aug.22nd, 6 weeks after material arrived. Corrosion likely happened internally.	
3	Smith, Patrick	8/29/2014	10/5/2014
look into the process of handling material and storage from department to department		Parts shall be processed upon receipt from supplier to ensure the parts do not sit exposed to the environment.	

Verification & Review			
Target Date 10/5/2014	Owner Downing, Eric M	Closed Date 10/5/2014	Closed By Smith, Patrick
Details Corrective actions complete.			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	

Work Order ID 115854***115854***

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June-09-14 11:33:35 AM

Item ID: D3302-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Doubler

Start Date: 4/04/14

Start Qty: 10.00

10

Cust Item ID:

Required Date: 4/04/14

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00

160

HandFinish

Memo

0.00

Hand Finishing

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

180

Identify as per dwg & Stock Location: _____

0.00

180

Packaging

Memo

0.00

Packaging

Work Order ID 115854***115854***

Page 4

June-09-14 11:33:35 AM

Item ID: D3302-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Doubler
Start Date: 4/04/14 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 4/04/14 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

w/o costed.
14-12-04

Picklist Print

Page 1

June-09-14 11:33:34 AM

Work Order ID: 115854

115854

Parent Item: D3302-1

D3302-1

Parent Item Name: Doubler

Start Date: 4/04/14

Required Date: 4/04/14

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev: A04.09.02New issueKJ/JLM
IPP Rev:B Now on Waterjet 07-06-25 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased		No		100	sf	503.0880	0.7708	9			

M6061T6S 063

6061-T6 .063 Sheet

**

CL14/06/27

Location

Loc Qty

Loc Code

MAT021

503.088

M124446

3.7

M126075

4.5

M127006

9

M127420

117.12

M128054

84.768

M128941

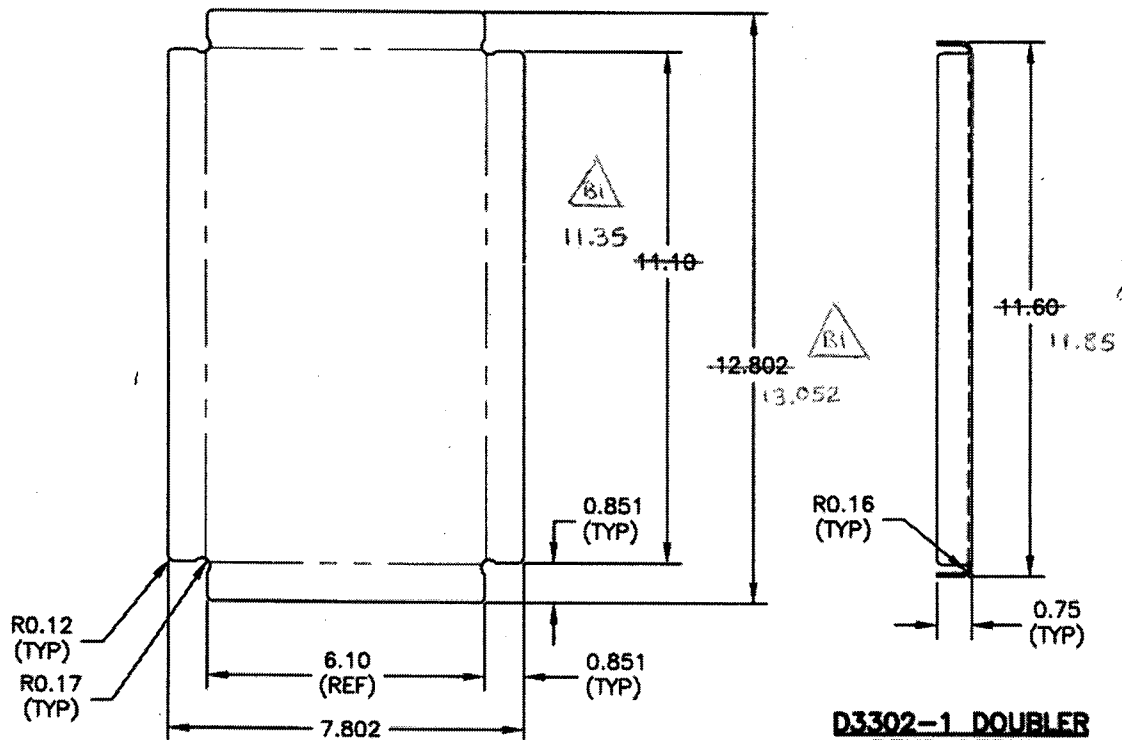
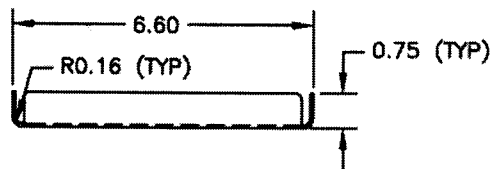
284

m129637

9

DART

DESIGN <i>TF</i>	DRAWN BY <i>TF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>TF</i>	APPROVED <i>TF</i>	DRAWING NO. D3302	REV. B SHEET 1 OF 4
DATE 04.11.18		TITLE DOUBLER	SCALE 1:4
A	04.07.06	NEW ISSUE	
B	04.11.18	REMOVE HOLES	
B1	<i>TF</i> 04.12.15	ADDED 0.25" TO THE LENGTH FOR -1/-3	
B2	<i>TF</i> 05.03.21	7.25 WAS 7.34 ; 8.952 WAS 9.042 ; 7.75 WAS 7.84 FOR D3302-3	

RELEASED
04.11.23 *TF***D3302-1 FLAT PATTERN****D3302-1 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

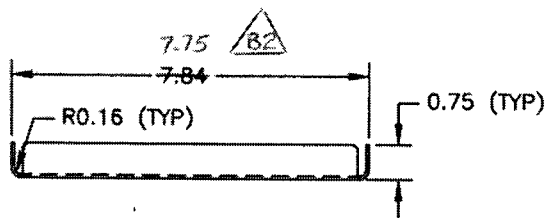
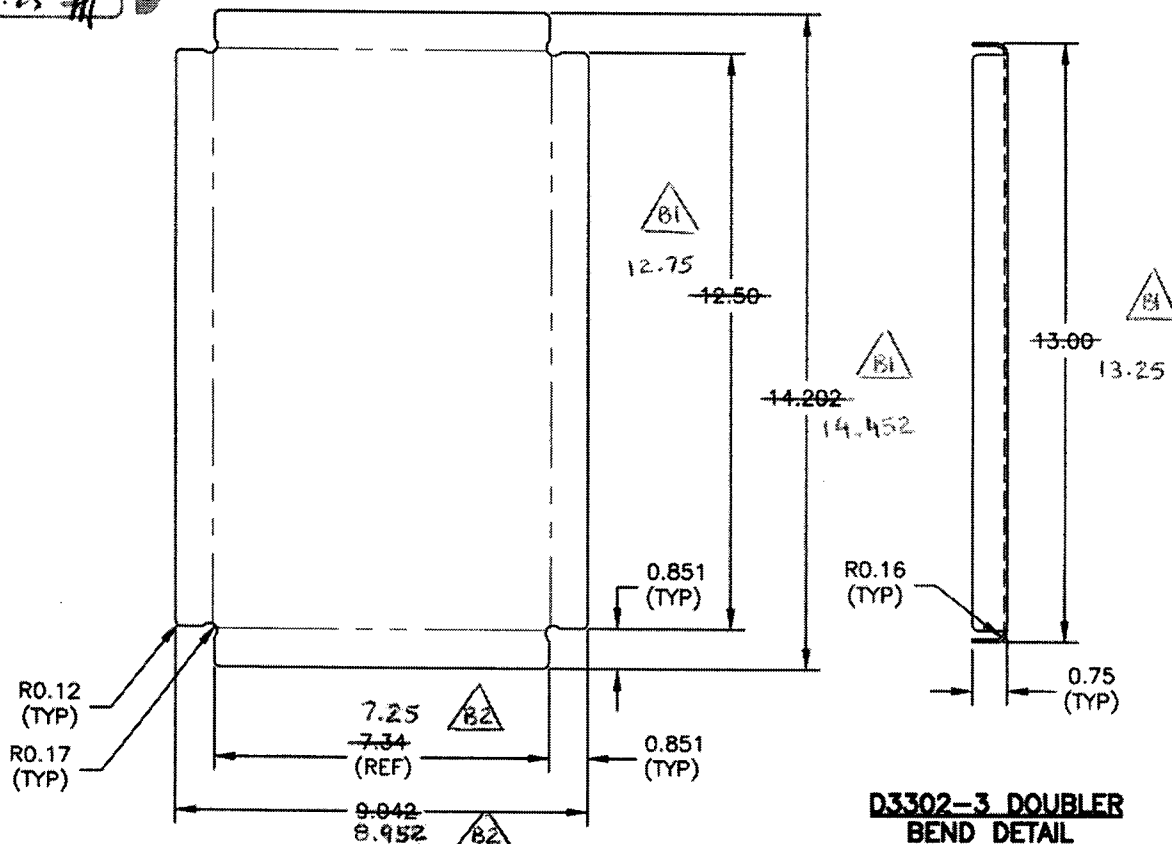
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DATE 04.11.18		TITLE DOUBLER	SCALE 1:4

RELEASED
04.11.23 *[Signature]*



D3302-3 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & BATCH USING FINE POINT PERMANENT MARKER

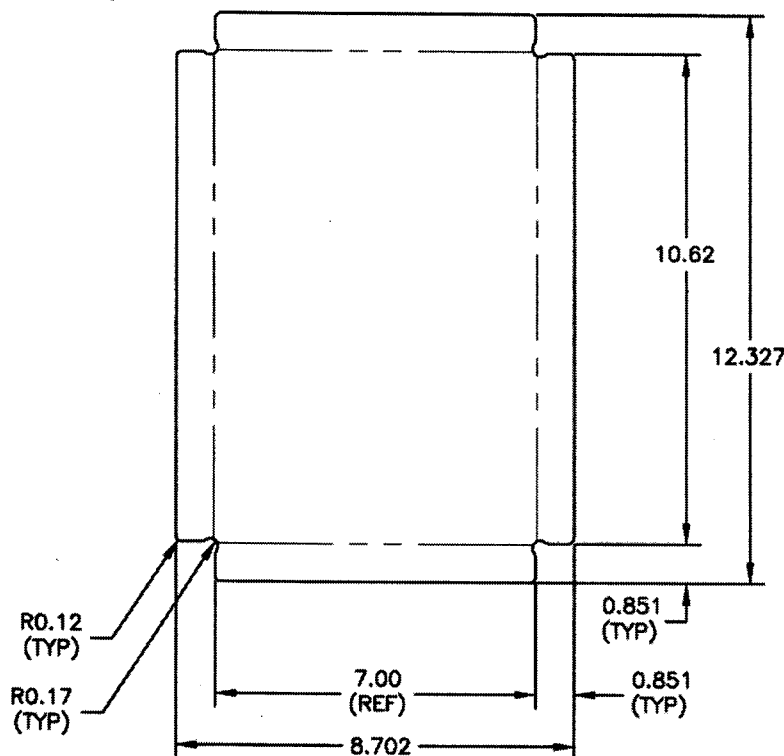
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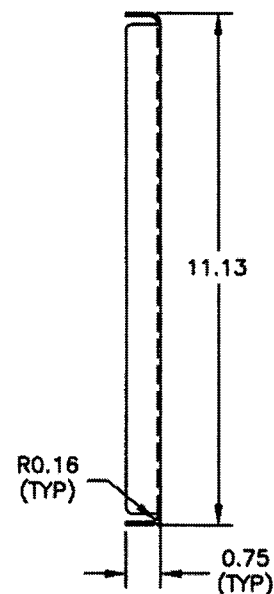


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3302	REV. B SHEET 3 OF 4
DATE 04.11.08		TITLE DOUBLER	SCALE 1:4

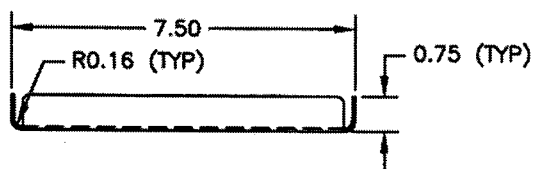
RELEASED
04.11.23 H



D3302-5 FLAT PATTERN



**D3302-5 DOUBLER
BEND DETAIL**



D3302-5 NOTES:

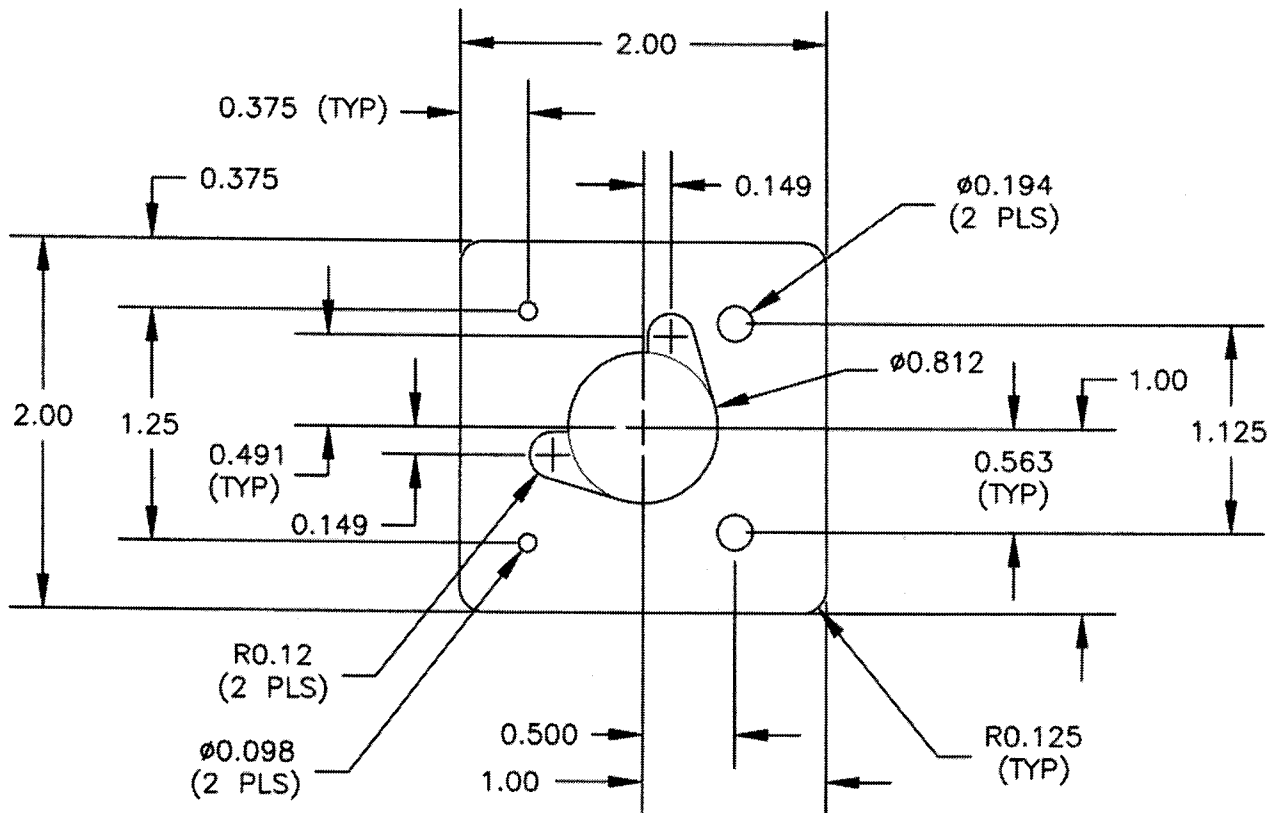
- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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CHECKED RF	APPROVED RF	DRAWING NO. D3302	REV. B SHEET 4 OF 4
DATE 04.11.18		TITLE DOUBLER	SCALE 1:1

RELEASED
04.11.23**D3302-7****D3302-7 NOTES:**

- 1) MATERIAL: 5052-H32 OR 6061-T6 (QQ-A-250/8 OR QQ-A-250/11)
0.040 THICK (REF. DART SPEC. M5052H32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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T.P.I. INDUSTRIES INC.

148 GOODFELLOW
DELSON, QUÉBEC J5B 1V4
CANADA
Tel: (450) 633-0484
Fax: (450) 633-0879

Packing Slip

Packing Slip No.: 6192
Date: 2014-07-10
Page: 1

Sold to:	Ship to:
Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada	Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada
Order No.: 24574	Sold By: JONATHAN LESSARD
Shipped By:	Ship Date: 2014-07-10
Tracking No.:	

Item No.	Unit	Description	Quantity
646.3711	Chaque	646.3711 clip	40
646.3712	Chaque	646.3712 clip	20
646.3712	Chaque	646.3712 clip	40
646.3713	Chaque	646.3713 gusset	40
646.3714	Chaque	646.3714 gusset	40
646.3717	Chaque	646.3717 doubler	30
646.3719	Chaque	646.3719 doubler	20
646.3719	Chaque	646.3719 doubler	40
d2365	Chaque	d2365 wearplate pin	30
d3283-1	Chaque	d3283-1 doubler	40
d3208-3	Chaque	d3208-3 pedal mount angle	20
d3290-1	Chaque	d3290-1 frame	30
d3302-1	Chaque	d3302-1 doubler	10
d3302-3	Chaque	d3302-3 doubler	10
d3363-1	Chaque	d3363-1 console	16
d4072-3	Chaque	d4072-3 airframe hinge backing plate	40
d4073-3	Chaque	d4073-3 door hinge backing plate	50
d4074-5	Chaque	d4074-5 backing plate	40
d4610-5	Chaque	d4610-5 shim	20

Comment: Net / 30 from date of invoice 2% svc. chg. on invoices over 30 days